

Thursday, August 25, 2016 10:36:15 AM

Item ID: D4935-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mounting Bracket

Start Date: 8/29/2016 **Start Qty:** ~~20.00~~

Cust Item ID:

Required Date: 9/19/2016 **Req'd Qty:** 20.00

Customer:

Reference:

DAS

Approvals: **Process Plan:** **21** **Date:** **AUG 25 2016** **Tooling:** _____ **Date:** _____
 9-89

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4935	B								

100

0.03

100

FLOW WATER JET

0.07

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr as required

110

0.00

1 10

QC2- Inspect parts off machine FAI/FAIB

0.03

QC

Quality Control

Memo

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SEP 13 2016

Work Order ID 150523

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150523

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Item ID: D4935-1 Accept ***N1900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Bracket
Start Date: 8/29/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 9/19/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.03				(40)			DAS 38 9-88 SEP 1 1 2016
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>54139</u> Memo	0.00 0.03				40			DAS 38 9-88 SEP 15 2016
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.33							MJS 16-09-15 MJS 16-09-15

Picklist Print

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Work Order ID: 150523

150523

Parent Item: D4935-1

D4935-1

Parent Item Name: Mounting Bracket

Start Date: 8/29/2016

Required Date: 9/19/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 13.10.02 NEW ISSE DD VERF:JLM IPP
REV:B 14.06.18 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased			No		sf	583.5663		0.237895			

M6061T6S 063

6061-T6 .063 Sheet

ack 10/09/02

Location

Loc Qty

Loc Code

MAT021

266.96

M133511

2.6

M134377

3.3

M134830

261.06

TPI

316.606316

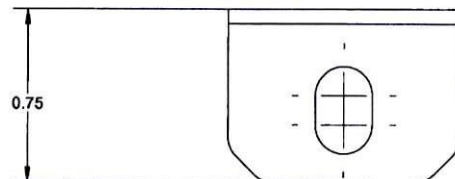
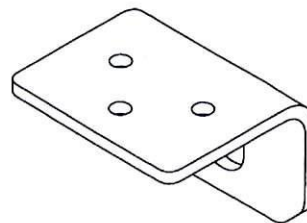
M134496

172.606316

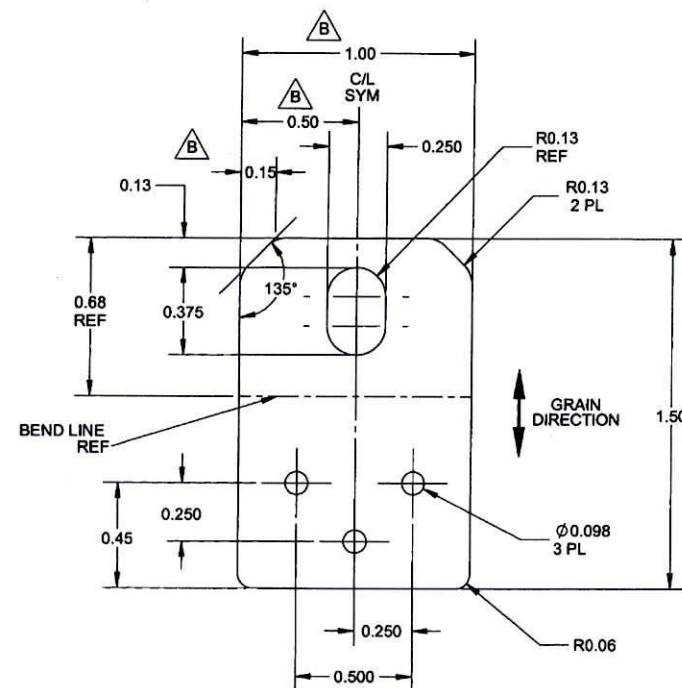
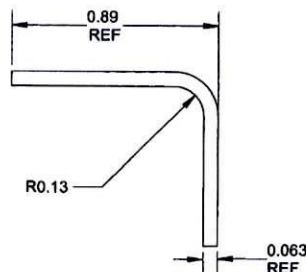
M134604

144

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150523 MWS
160825



D4935-1 EAPS MOUNTING BRACKET



D4935-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: D4935-1: MAKE FROM D4935-1F
D4935-1F: 6061-T6/T62 ALUMINUM SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209, REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK GLOSS" (4.3.5.13) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 LBS

RELEASED
2014-06-16

B	ADD 0.15 X 45° CHAMFER, 2 PL, 1.00 WAS 1.09	DB	14.01.16
A	NEW ISSUE	DB	13.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	DD	D4935	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	EAPS MOUNTING BRACKET	NTS
DATE	14.01.16	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED